

Ship July 4

D2362-3

B103257

REVE

Page 1

Work Order ID 103257

103257

June-20-13 9:14:05 AM

Item ID: D2362-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Support Bracket
 Start Date: 6/20/13 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 7/02/13 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2362	Rev E1								

100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA800 Rev: <u>AA</u> & Dwg D2362 Rev: <u>E</u> 2-Deburr per dwg D2362								
						<u>15</u>			<u>SL13-6-22</u>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
						<u>15</u>	<u>0</u>		<u>SL13-6-22</u>
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
						<u>15</u>	<u>0</u>		<u>SL13/06/24</u>

Work Order ID 103257

103257

Page 2

June-20-13 9:14:05 AM

Item ID: D2362-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Support Bracket
 Start Date: 6/20/13 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 7/02/13 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					15			SI 13-6-22
Small Fab	Memo	0.00							
Small Fab	Debur								
140		0.00							
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:00								
	FINISH TIME: 11:30								
150		0.00							
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

15x m/f 13/06/27

15x d 13/06/22

MI25620

3200P

11:30

Work Order ID 103257***103257***

Page 4

June-20-13 9:14:05 AM

Item ID: D2362-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Support Bracket

Start Date: 6/20/13 Start Qty: 15.00

15

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/7/8

ME
13-7-195

Picklist Print

June-20-13 9:14:04 AM

Page 1

Work Order ID: 103257

Parent Item: D2362-3

Parent Item Name: Step Support Bracket

Comments: IPP: G00.05.18Added inspection level 8EC

Start Date: 6/20/13

Required Date: 7/02/13

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2265		Manufactured	No			160	Each	35.0000	1	15			
Step Bracket													

Location	Loc Qty	Loc Code
----------	---------	----------

ST488	35	
44114	5	
97950	30	

5
10

amk 13/06/22

D2397-1		Manufactured	No			160	Each	20.0000	1	15			
Rubber Cushion													

Location	Loc Qty	Loc Code
----------	---------	----------

GA	1	
72737	1	
ST009	19	
99483	19	

15

FF 13-07-03

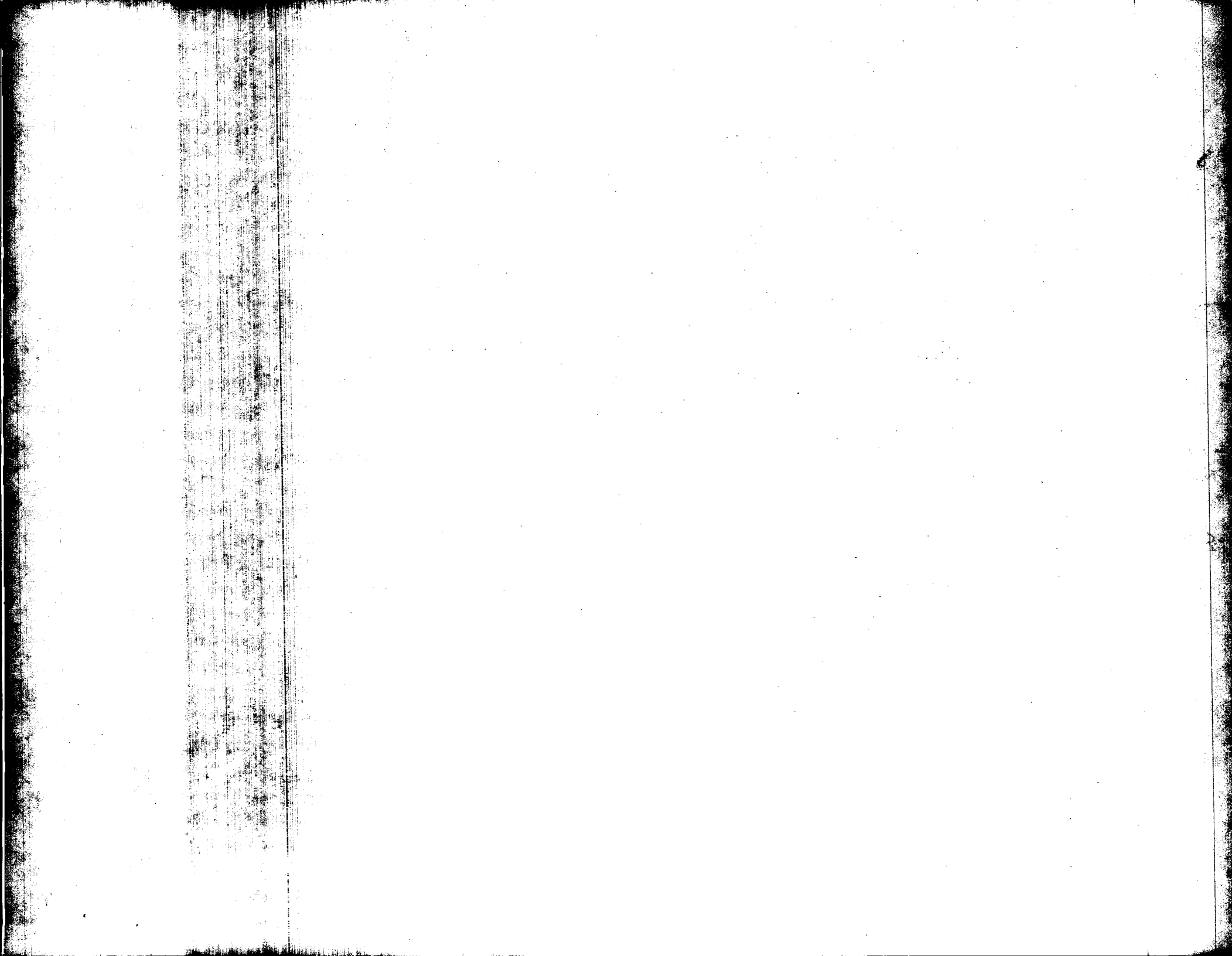
D2397-3		Manufactured	No			100	Each	19.0000	1	15			
Rubber Cushion													

Location	Loc Qty	Loc Code
----------	---------	----------

ST009	19	
99484	19	

B 10 3 803

FF 13-07-03





RELEASED
98.12.14 KE

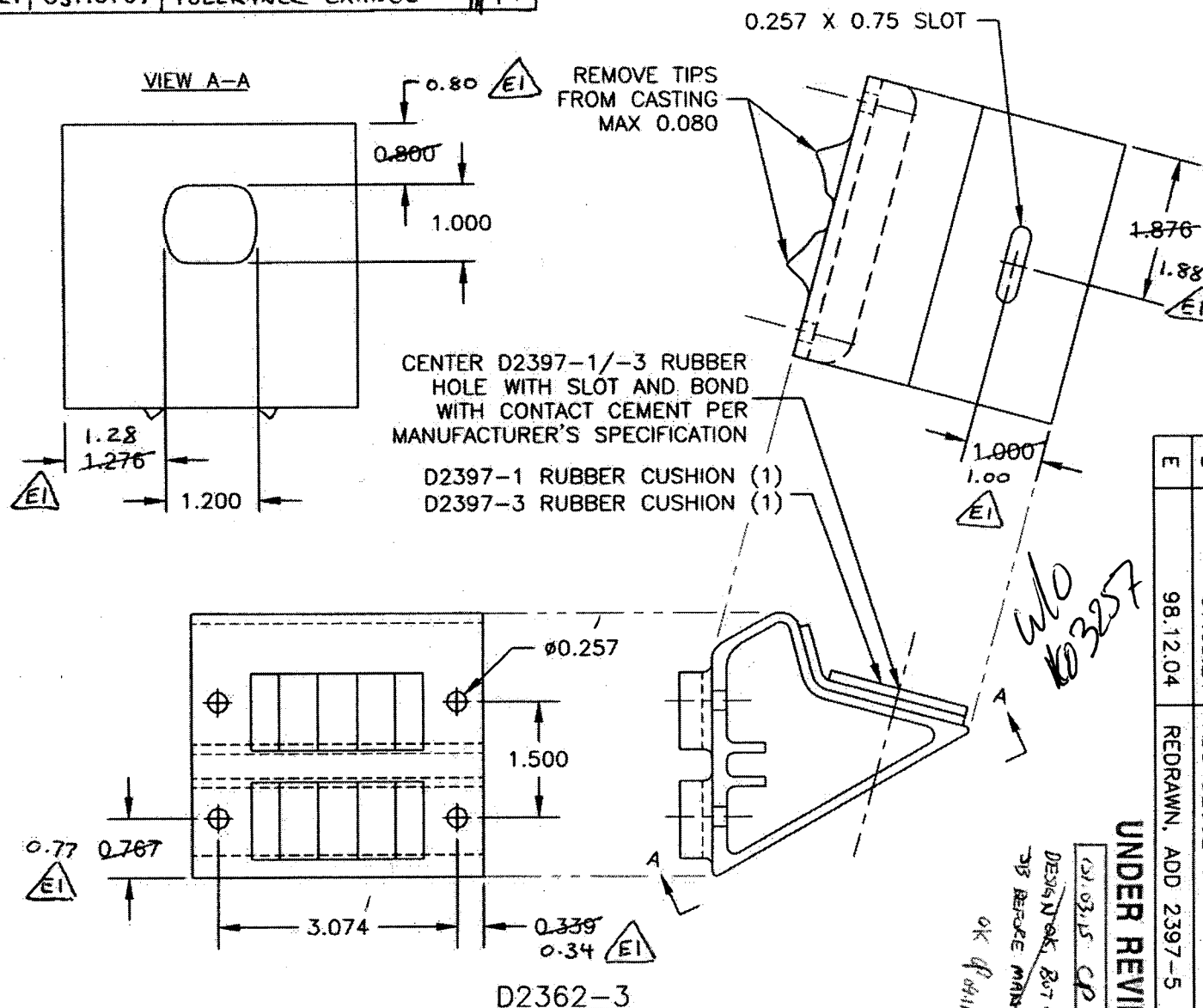
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA	REV. E
BW	<i>CP</i>		
CHECKED KE	APPROVED <i>CP</i>	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
D23 BEFORE MANUFACTURE
OK 05/11/04

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:

MAKE FROM D2265

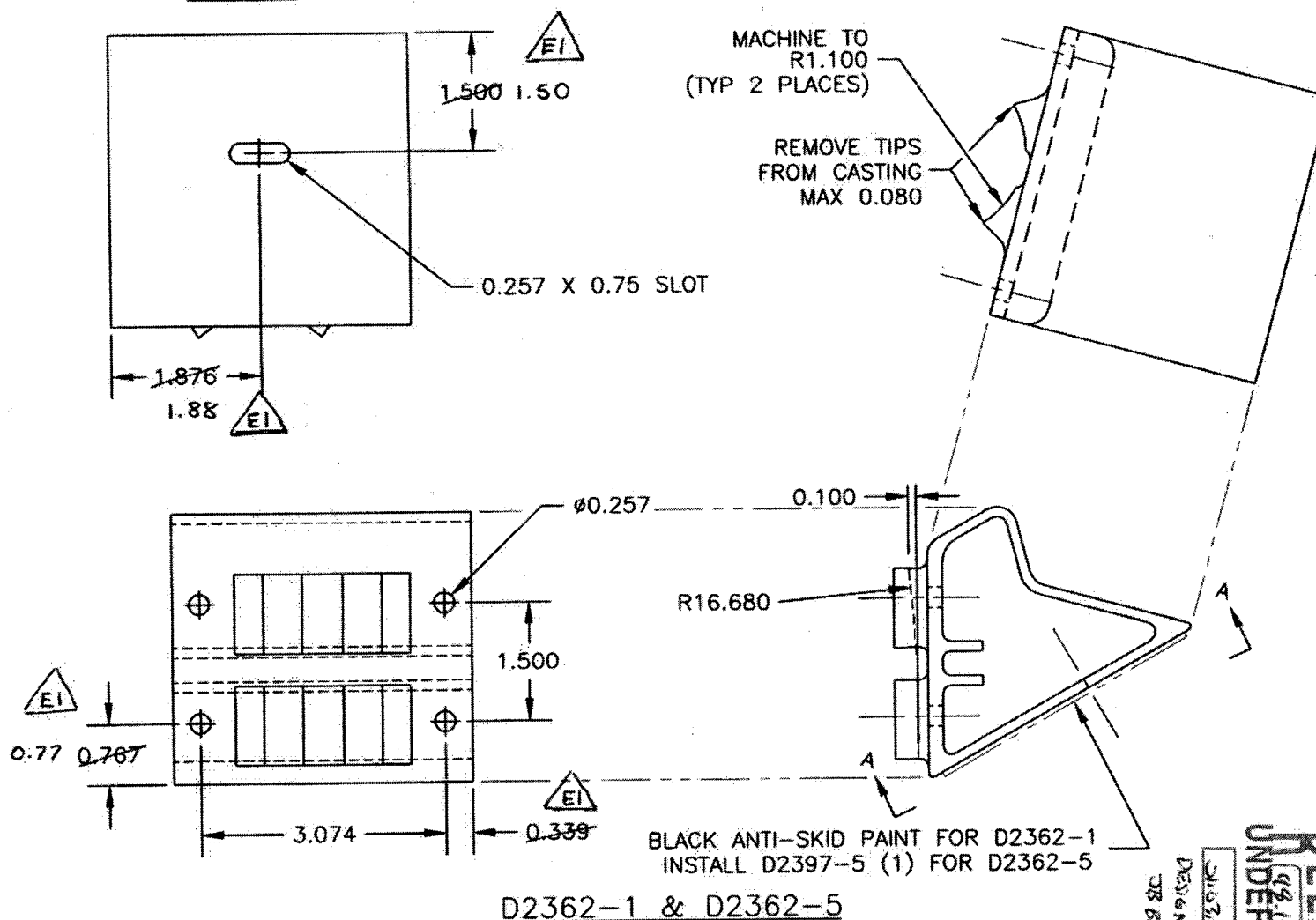
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE 1:2

VIEW A-A



NOTES:

MAKE FROM D2265.

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

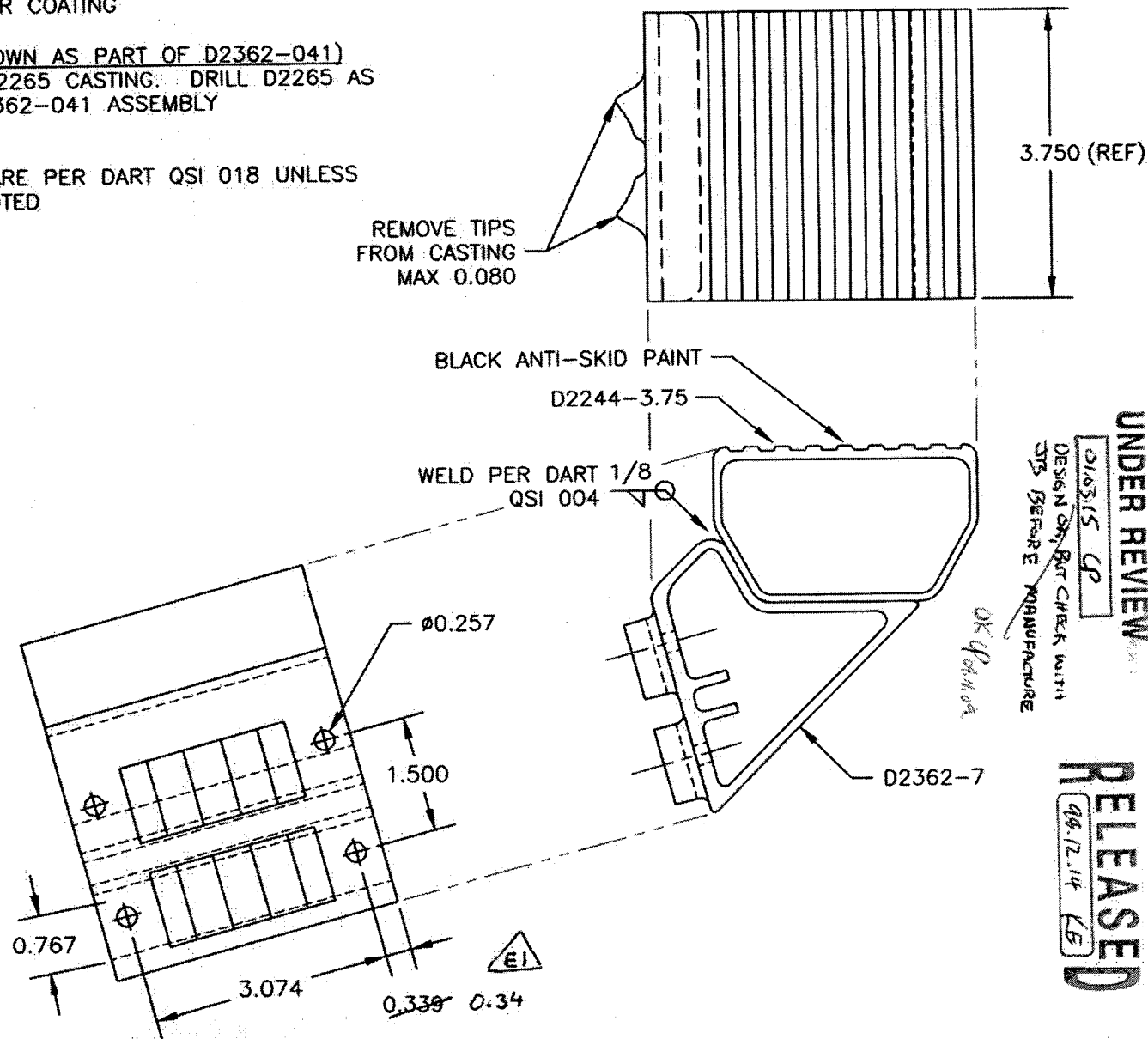
RELEASED
98.12.14
UNDER REVIEW

DESIGNED BY: CP
OR BEFORE MANUFACTURE

OK 98.12.09

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



DESIGN	DRAWN BY <i>BP</i>		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. E
BW					
CHECKED <i>KE</i>	APPROVED <i>BP</i>	DRAWING NO. D2362		SHEET 3 OF 3	
DATE 98.12.04	TITLE STEP SUPPORT BRACKET		SCALE 1:2		

UNDER REVIEW

98-12-14 KE

Copyright 1995 by DART AEROSPACE LTD

